

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022035**Date Inspected:** 21-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhou Zhong Hai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG COMPONENT**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Subhasis Bera was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

In process Inspection

Bay #14

This QA Inspector observed the following work in progress:

SMAW in the 2G position for the OBG Segment 14W, weld No. DP3168-001-011. The welder is identified as #067588. ZPMC QC is identified as Mr. Shi Lei. The welding variables recorded by QC appear to comply with WPS-B-P-2212-Tc-U4b-FCM-1. The welding variables were recorded at, Amperage 171, volts 24.7. The In-process SMAW appears to be progressing in compliance with approved contract documents.

SMAW in the 3F position for the OBG Segment 14W, weld No. DP3168-001-051. The welder is identified as #044504. ZPMC QC is identified as Mr. Shi Lei. The welding variables recorded by QC appear to comply with WPS-B-P-2113-FCM-1. The welding variables were recorded at, Amperage 152, volts 24.4. The In-process SMAW appears to be progressing in compliance with approved contract documents.

Trial Assembly

This QA Inspector observed the following work in progress:

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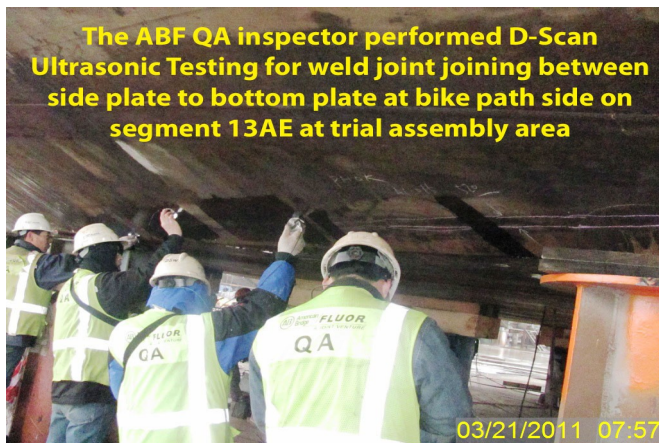
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SMAW in the 3G position for OBG segment 13AE, welding of weld No. SEG3007Y-340. The Welder is identified as 066418. ZPMC Quality Control is identified as Mr. Liu hua jie. The welding variables recorded by QC personnel appeared to comply with WPS-B-P-2213-TC-U4b-FCM-1. The welding variables were recorded at, Amperage 162, volts 24. The In-process SMAW appears to be progressing in compliance with approved contract documents.

SMAW in the 3G position for OBG segment 13AE, welding of weld No. SEG3007Y-328. The Welder is identified as 037743. ZPMC Quality Control is identified as Mr. Liu hua jie. The welding variables recorded by QC personnel appeared to comply with WPS-B-P-2213-TC-U4b-FCM-1. The welding variables were recorded at, Amperage 157, volts 24.3. The In-process SMAW appears to be progressing in compliance with approved contract documents.

SMAW in the 3G position for OBG segment 13AE, welding of UT repair weld No. DP3076-001-012. The Welder is identified as 200113. ZPMC Quality Control is identified as Mr. Liu hua jie. The welding variables recorded by QC personnel appeared to comply with WPS-345-SMAW-3G(3F)-FCM-REPAIR-1. The repair report is identified as WR20471. The welding variables were recorded at, Amperage 142, volts 23.5. The In-process SMAW appears to be progressing in compliance with approved contract documents.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Bera, Subhasis

Quality Assurance Inspector

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Reviewed By: Dsouza,Christopher

QA Reviewer